

Work Order ID 62661

Thursday, October 07, 2010 8:05:55 AM

Page 1

Item ID: D3537-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearpad

Start Date: 10/6/2010 Start Qty: 50.00

Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 50.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10/10/07

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3537

Rev C

100

0.00

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537 ☒ Dwg Rev: C ☐ Prog Rev: C ☐ 2-Deburr if necessary

304.063

10-10-7

59

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

10-10-7

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

8 10/10/08

counted
x55

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 3

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Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Disolubos

count
758

170

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: *2:15* OVEN TEMPERATURE:
320 FINISH TIME: *3:15*

59 *BL 10-11-3*

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=> 10/11/03

59 *0*

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Page 4

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Revision ID:

Stop



Item Name: Wearpad

Start Date: 10/6/2010 Start Qty: 50.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location:

EP-17

0.00



Packaging

Memo

0.00

Packaging

59 BL 10-11-3

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/11/04**MF**10-11-3*

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NOTE: Date & initial all entries

Picklist Print

Thursday, October 07, 2010 8:06:00 AM

Page 1

Work Order ID: 62661

Parent Item: D3537-1

Parent Item Name: Wearpad





Start Date: 10/6/2010

Required Date: 10/15/2010

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	70.6100	0.106	5.578947	6.3		
304/316 Sheet .063											B10-107		

Location

Loc Qty

Loc Code

MAT

64.77

111323

0

115688

64.77

MAT20

5.84

115440

5.84

115688

59

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	<i>62661</i>
Description: Wearpad		Part Number:	D3537-1
Inspection Dwg: D3537 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.250	+/-0.010	4.252	*		VIB02	
3.500	+/-0.010	3.499	*		V	
1.965	+/-0.010	1.969	*		V	
2.795	+/-0.010	2.795	*		V	
3.625	+/-0.010	3.626	*		V	
0.220 x 0.380	+/-0.010	0.21 x .380	*		V	

Measured by: <i>AB</i>	Audited by: <i>S</i>	Prototype Approval:	N/A
Date: 10-10-7	Date: 10/10/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM <i>JA</i>	<i>JA</i>

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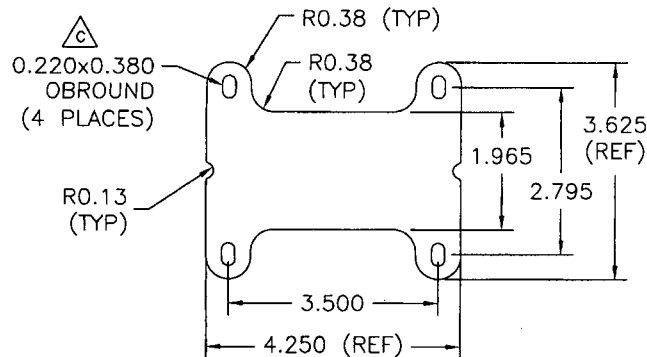
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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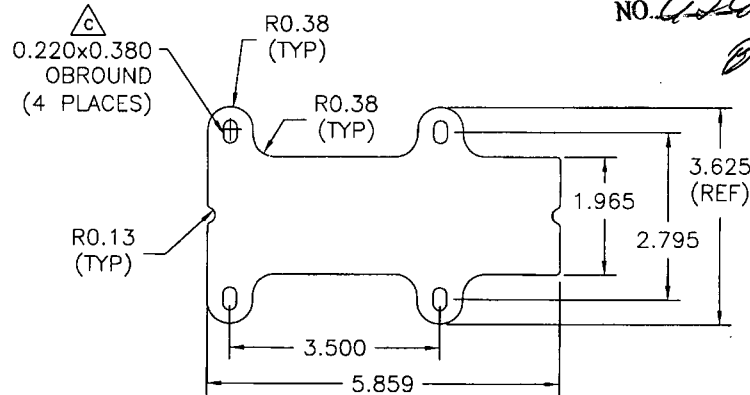
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO CHANGE IF
WITHOUT THE
WORK ORDER
NO. 62461
07-10-07

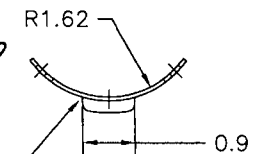
D3537-1F FLAT PATTERN



D3537-3F FLAT PATTERN

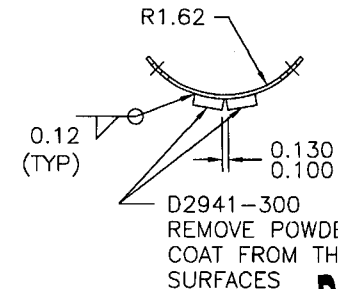


SECTION A-A



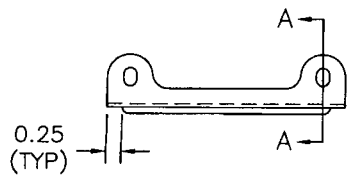
APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

SECTION B-B

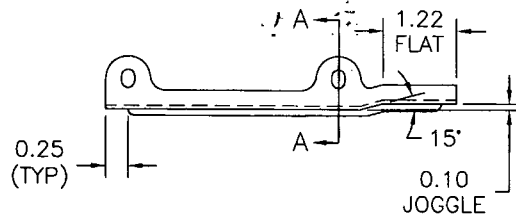


RELEASED
07-05-03 PH
PCF ELN
962

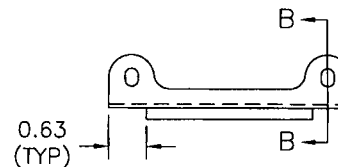
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



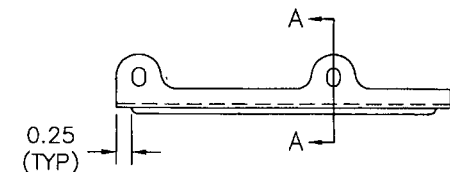
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
SHEET 1 OF 1		SCALE 1:2

DART DART AEROSPACE USA, INC.
PORT HADLOCK, MA

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